

# Work Order ID 108310

Tuesday, October 15, 2013 4:01:58 PM

**\*108310\***

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Item ID: D3440-9 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)  
 Start Date: 10/15/2013 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 10/31/2013 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: ME Date: 13-10-15 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3440	Rev A								

100 BAND SAW 0.00  
**\*100\***  
 Bandsaw Memo 0.00  
 Jeaspa Bandsaw Cut blank: 1.250" x 1.250" x 1.825" long

110 HAAS CNC VERTICAL MACHINING #1 0.00  
**\*110\***  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Machine as per Folio FA535 and Dwg D3440Dwg Rev: A Identify as  
 D3440-9Folio Rev: AA Debur

120 QC2- Inspect parts off machine FAI/FAIB 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control

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Item ID: D3440-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Start Date: 10/15/2013 Start Qty: 6.00 \*6\*

Cust Item ID:

Required Date: 10/31/2013 Req'd Qty: 6.00 \*6\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

DAS  
40  
9-89

13/10/19

6

Ø

140

Identify as per dwg & Stock Location: M/ezz-2 0.00

\*140\*

Packaging

Memo

0.00

Packaging

6x

DAS  
28  
9-89

13-10-21

150

QC21- Final Inspection - Work Order Release 0.00

\*150\*

QC

Memo

0.00

Quality Control

MF/Rm 13/10/21

MF

13-10-21

# Picklist Print

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Work Order ID: 108310

Parent Item: D3440-9

Start Date: 10/15/2013

Required Date: 10/31/2013

Parent Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A05.06.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.250 6061-T6 Bar 1.25 x 1.25		Purchased	No			100	f	34.9861	0.1625	2			

Location

Loc Qty

Loc Code

MAT003

34.9861421

122521

0.6638421

123649

2.978

124443

12.5193

m126647

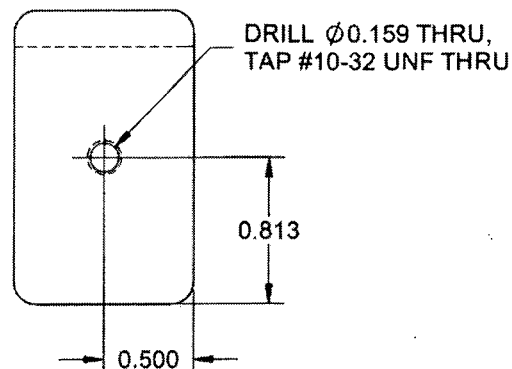
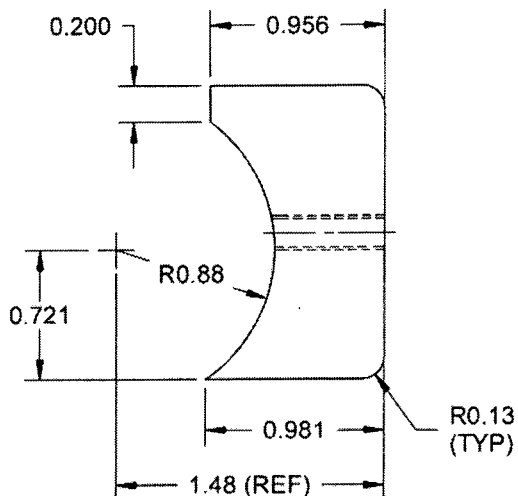
18.825

2.958

MH 13/10/17



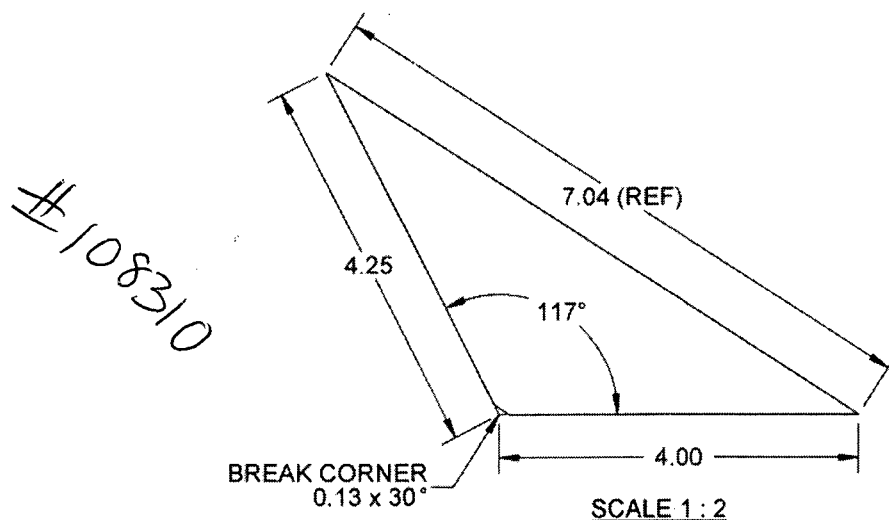
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3440</b>	REV. A SHEET 5 OF 7
DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

**RELEASED**  
*[Signature]*  
05/08/13



**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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